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(54) BIAXIALY ORIENTED POLYOXYMETHYLENE FILM

(57)Abstract:

PURPOSE: To improve its surface smoothness drastically without spoiling excellent mechanical and thermal properties, by a method wherein a biaxially oriented polyoxymethylene film is remelted at the melting point or higher and after isothermic recrystallization into a filmy state at a specific temperature, a number of spherulites are specified.

CONSTITUTION: Raw fabric is led to a lateral stretching machine 4, stretched laterally and then longitudinally with stretching rolls 8, 9. Then after cooling with cooling rolls 10, 11 the raw fabric is wound up. In the case where a biaxially stretched polyoxymethylene film is remelted/recrystallized, it is necessary to recrystallize the film so that a form of the film after recrystallization becomes a filmy state where it is in uniform thickness and flat. Although it is good if the remelting, this molten matter is shifted at once to a state under a constant temperature state of 140°C while crystallization does not progress.

Recrystallization is performed under the state and a number of spherulites of polyoxymethylene within crystalline structure of the surface of the film measured by a polarization microscope with a direction light

